

Split

ASAP

Work Order ID 56520-1

March 1, 2010 9:08:53 AM

Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 3/01/10

Start Qty: 6.00

Required Date: 3/02/10

Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3494	Rev C

100

0.00



Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: C PRELIM

Prog Rev: C

2-Deburr if necessary

0.00

B10-31

(15)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC
Quality Control

Memo

0.00

B10-31

Work Order ID 56520

March 1, 2010 9:08:53 AM

Page 2

Item ID: D3494-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Stub Cover

Start Date: 3/01/10 Start Qty: 6.00

Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

81063/01 checks to problem Day

Memo

0.00

QC APPROVAL

(75)

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

SB 10/03/01

(1)

P10 →

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00







81063/01 to problem Day

QC APPROVAL

1

1003-02

Quality Control

W/O: 56520		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/03/01	* 130.1 130.2	Perm. change weld corners per AS 1004 AS 1004 + Dwg. - Build inter welds	lpc	10.03.01	①		 10/03/01	
	* 130.2	-> QC  inspect ground welds per AS 2004 - QC 5	PD	100302	①		 10/03/01	
				10.03.02	1	10.03.02	10/03/01	

Part No: D 3494-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56520

March 1, 2010 9:08:54 AM



Page 3

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 3/01/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 105612ST 8:45AM

Memo

Temp: 320°F

FIN 9:15AM

0.00

⇒ JH

10105/02

ⓧ

ⓧ

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

BK

10-03-2

ⓧ

ⓧ

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 224

Memo

0.00

0.00

10-3-2 54

ⓧ

POSITIVE RECALL

EFFECTIVE

10/03/07

AUTH

W

RELEASED

UP

DATE

10/03/02

1

Work Order ID 56520

March 1, 2010 9:08:54 AM



Page 4

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 3/01/10 Start Qty: 6.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

ME

10-3-2

Picklist Print

March 1, 2010 9:08:52 AM

Page 1

Work Order ID: 56520



Parent Item: D3494-1



Parent Item Name: Stub Cover

Start Date: 3/01/10

Required Date: 3/02/10

Comments: IPP Rev:A New Issue 06-05-18 JLM
IPP rev B ecn 888 06.12.13 EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	179.8899	4.3200	11		



304/316 Sheet .063



B10-3-1

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

179.8898737

106860

8.0295

111924

25.1689737

112442

29.8865

113295

116.8049

113295

15

DART AEROSPACE LTD		Work Order: S6520
Description: STUB COVER		Part Number: D3494-1
Inspection Dwg: D3494-1 Rev: 1 222 C		Page 1 of 1

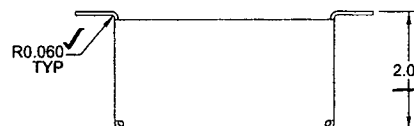
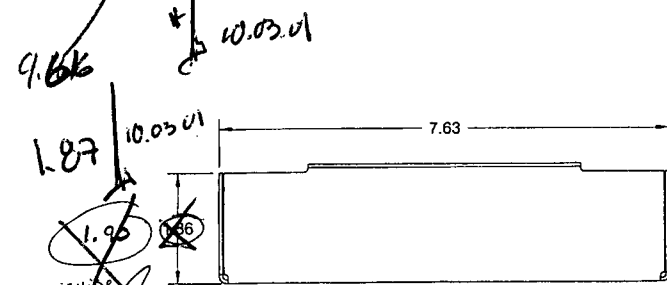
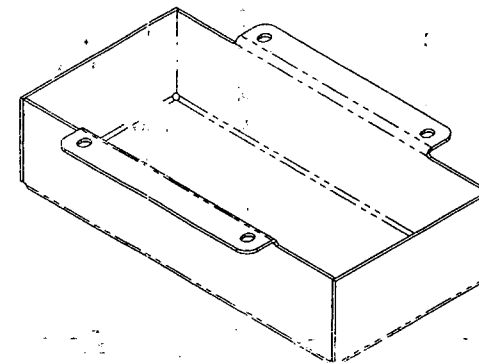
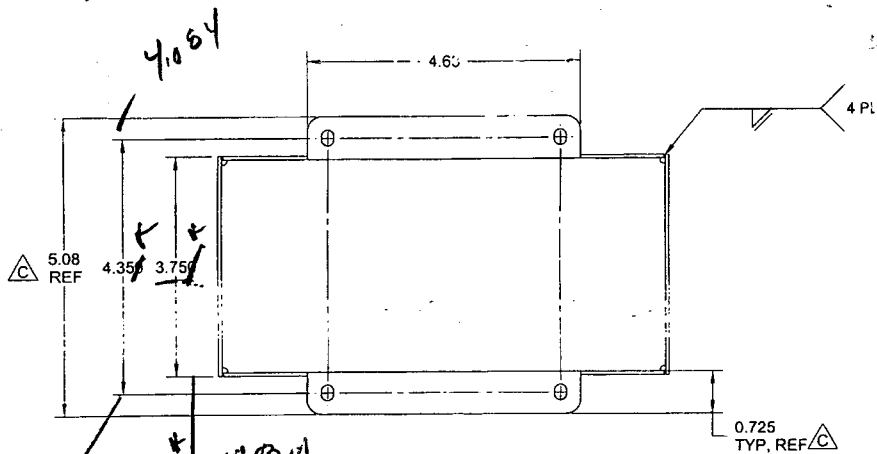
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.208	$\pm .010$.208	✓			
.368	$\pm .010$.368	✓			
.766	$\pm .010$.767	✓			
2.528	$\pm .010$	2.527	✓			
6.278	$\pm .010$	6.280	✓			
8.039	$\pm .010$	8.040	✓			
8.443	$\pm .010$	8.443	✓			
8.805	$\pm .010$	8.810	✓			
1.831	$\pm .010$	1.827	✓			
3.261	$\pm .010$	3.261	✓			
3.604	$\pm .010$	3.606	✓			
3.940	$\pm .010$	3.941	✓			
7.886	$\pm .010$	7.884	✓			
9.316	$\pm .010$	9.318	✓			
11.148	$\pm .010$	11.149	✓			
.063	$\pm .010$.058	✗			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-3-1	Date: 10/03/01	Date:	N/A
checked to photo Dwg.		Revised by	Approved
Rev A	Date	Change New Issue	KJ/JLM

REFERENCE ONLY



D3494-1 STUB COVER

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
DSS 08.10.31

NOTES:

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.44 lbs
- 8) WELD PER DART QSI 004

C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". C5-1 0.725 DIM WAS 0.65.	AJS	08.10.31
B	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.31		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3494 REV. C
SHEET 1 OF 2

TITLE SCALE
STUB COVER NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

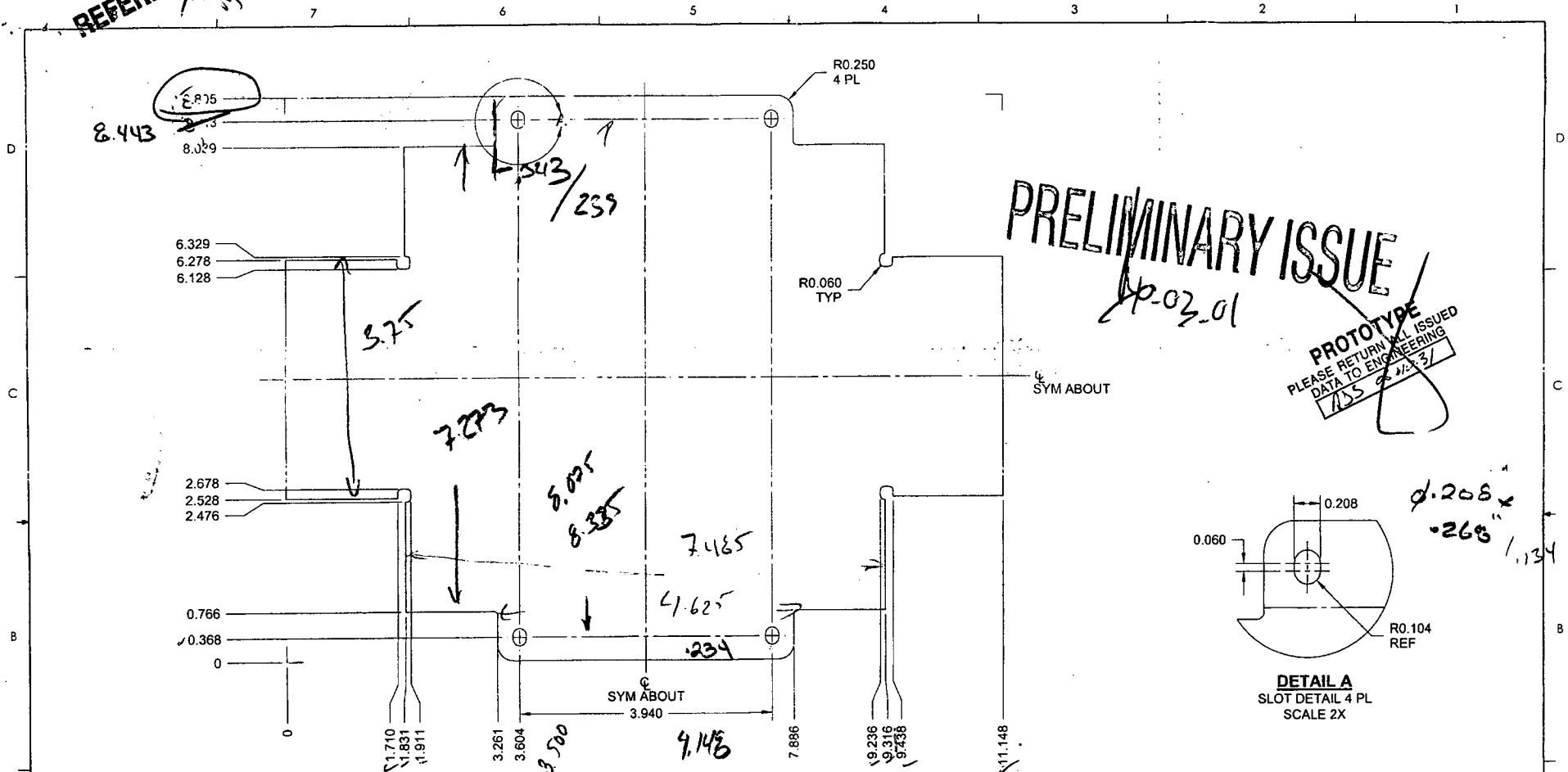
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

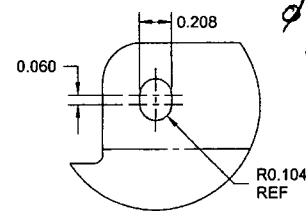
REFERENCE ONLY



PRELIMINARY ISSUE

10-02-01

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
ASS 21/3/



D3494-1F STUB COVER FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL (0.060 THICK) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE COMPLETED PART WEIGHT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3494	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER	NTS
DATE	08.10.31	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

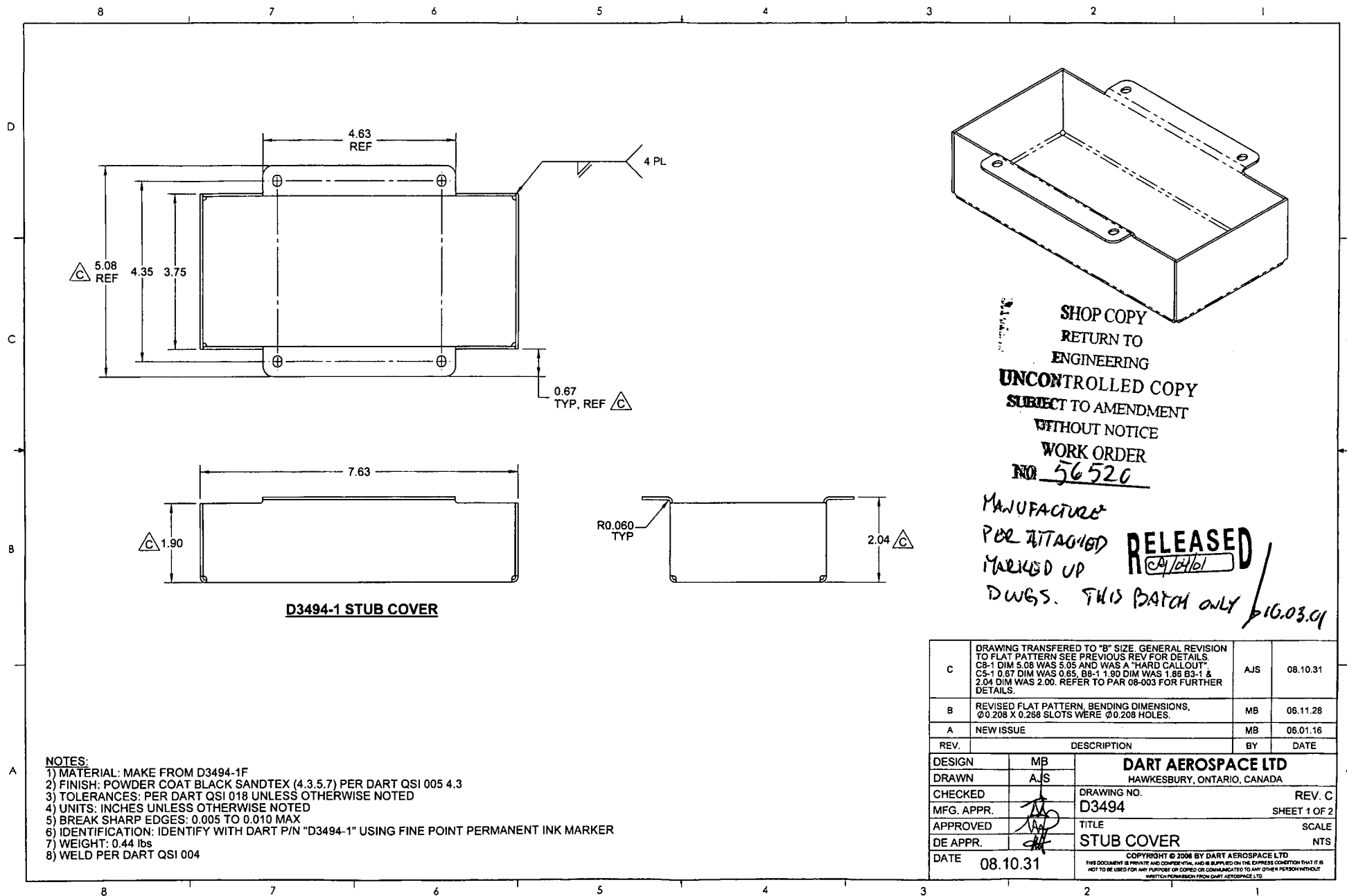
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. CS-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". CS-1 0.67 DIM WAS 0.65, BS-1 1.90 DIM WAS 1.86 BS-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3494	SHEET 1 OF 2
APPROVED		TITLE	SCALE
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- NOTES:**
- 1) MATERIAL: MAKE FROM D3494-1F
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 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.44 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
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 WORK ORDER
 NO 56520
 MANUFACTURE
 PER ATTACHED
 MARKED UP
 DWGS. THIS BATCH ONLY
 10.03.01

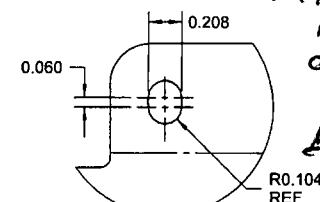
D3494-1F STUB COVER FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
16 GAUGE (0.060 THICK)
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE COMPLETED PART WEIGHT

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3494	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER	NTS
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 NO. 36520
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 08/03/01



DETAIL A
 SLOT DETAIL 4 PL
 SCALE 2X

RELEASED
 07/04/01